



NOTES:

1. WHEN MACHINING VACUUM PARTS, USE OF SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:
A) CIMCOOL 5 STAR 49
B) TRIM SOL
2. THIS IS A UHV PART. THE PART MUST GO THROUGH A MULTIPLE STEP CLEANING PROCESS INVOLVING DEGREASING, WASHING AND DRY NITROGEN BLOWDOWN.
3. KEEP THE PART CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.
4. DIMENSIONS IN [] ARE MILLIMETERS AND FOR REFERENCE ONLY.
5. SURFACE ROUGHNESS $63 \sqrt{\text{ }}$

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION		MATERIAL / SPEC		QTY								
<div style="display: flex; justify-content: space-between;"> <div> <p>UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES</p> <p>TOLERANCES</p> <table border="1"> <thead> <tr> <th>DECIMALS</th> <th>ANGULAR</th> </tr> </thead> <tbody> <tr> <td>.X - .03</td> <td>- .25</td> </tr> <tr> <td>.XX - .01</td> <td></td> </tr> <tr> <td>.XXX - .005</td> <td></td> </tr> </tbody> </table> <p>SURFACE ROUGHNESS $63 \sqrt{\text{ }}$</p> <p>REMOVE ALL BURRS AND BREAK SHARP EDGES .03 MAX.</p> <p>SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ANSI B46.1</p> <p>DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST ANSI Y14.5</p> <p>DO NOT SCALE DRAWING</p> </div> <div> <p>LOG NUMBER A2471100</p> <p>DRAWN BY R. KRAKORA</p> <p>CHECKED BY J.CHANG</p> <p>DESIGNER KRAKORA/CHANG</p> <p>RESPONSIBLE ENGINEER J.CHANG</p> <p>MATERIAL SST 304</p> </div> <div> <p>DATE 5/30/96</p> <p>DATE 6/18/96</p> <p>DATE 5/30/96</p> <p>DATE 6/18/96</p> </div> <div> <p>CHIEF DESIGN ENGINEER D.SHU</p> <p>GP LEADER T.M.KUZAY</p> <p>PROJECT MGR.</p> <p>APPROVED/RELEASED</p> </div> <div> <p>THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY</p> <p>TITLE ADVANCED PHOTON SOURCE Y3-30 MIRROR MOUNTS ASSEMBLY FOR SRICAT 2-BM-A 1200mm MIRROR PLUNGER GUIDE</p> </div> </div>							DECIMALS	ANGULAR	.X - .03	- .25	.XX - .01		.XXX - .005	
DECIMALS	ANGULAR													
.X - .03	- .25													
.XX - .01														
.XXX - .005														
SYM		CHANGE DESCRIPTION	BY	CHKD	DATE									
REVISIONS														
SCALE		1:1	SIZE	B	DRAWING NUMBER									
SHEET		1 of 1	P4105091203-300008-00											